

Work Order ID 58468

May 7, 2010 10:22:54 AM



Page 1

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Bracket

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RP

Date: *10-5-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4039

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-1_BLANK

B10-S-12



110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA880 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

amr 10/05/19

4

Work Order ID 58468

May 7, 2010 10:22:54 AM



Page 2

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Bracket

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

am 10/05/19

4

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

H.A 10/05/19

4

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

201 10/05/25

4

0

Hand Finishing

Work Order ID 58468

May 7, 2010 10:22:54 AM



Page 3

Item ID:	D4039-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Bracket				Stop	
Start Date:	07/05/2010	Start Qty: 4.00				
Required Date:	14/05/2010	Req'd Qty: 4.00				
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo: START: 8:15pm TEMP: 320°F FIN: 3:45pm	0.00 0.00	=) 10/05/25			4	0		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4			BR 10-5-27
170 Packaging Packaging	Identify as per dwg & Stock Location: 58467 Memo	0.00 0.00	58 10/05/26			4			

Work Order ID 58468

May 7, 2010 10:22:54 AM



Page 4

Item ID: D4039-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Bracket

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31

MF

10-5-27

Picklist Print

May 7, 2010 10:22:59 AM

Page 1

Work Order ID: 58468



Parent Item: D4039-1



Parent Item Name: Fwd Bracket

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	78.5000	3			



6061-T6 Bar 1.00 x 15.00



UB 10-5-12

Location

Loc Qty

Loc Code

MAT

72

114562

72

MAT07

6.5

9544

6.5

114562

DART AEROSPACE LTD		Work Order:	58468
Description: FWD BRACKET		Part Number:	D4039-1
Inspection Dwg: D4039 Rev: 4		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

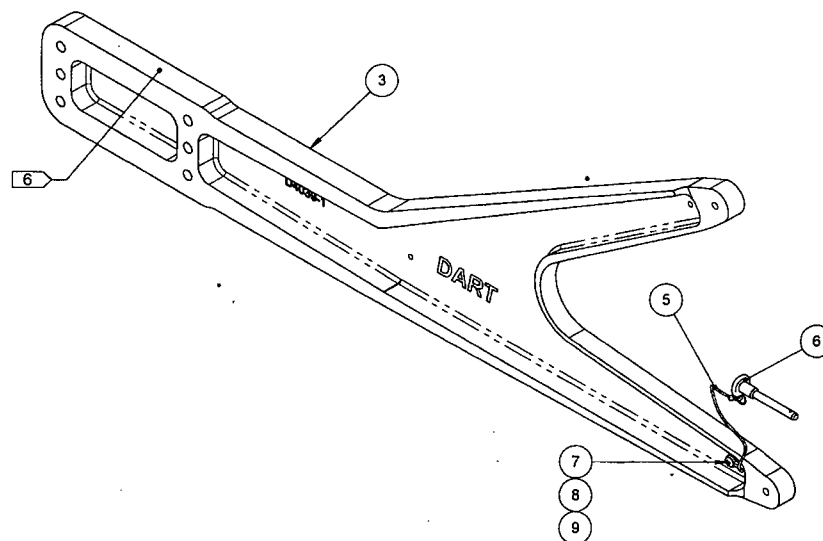
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	$\pm .030$	1.020	✓			
34.40	$\pm .030$	34.400	✓			
.730	$\pm .008$.739	✓			
2.250	$\pm .010$	2.250	✓			
.875	$\pm .010$.875	✓			
.875	$\pm .010$.875	✓			
6.000	$\pm .010$	6.000	✓			
.557	$\pm .010$.557	✓			
.300	$\pm .010$.298	✓			
.200	$\pm .010$.202	✓			
Ø.261	$\pm .006$	Ø.264	✓			
Ø.203	$\pm .005$	Ø.203	✓			
Ø.391	$\pm .006$	Ø.396	✓			
.19	$\pm .030$.195	✓			
4.00	$\pm .030$	4.001	✓			
1.00	$\pm .030$.999	✓			
R.13	$\pm .030$	R.125	✓			
3.73	$\pm .030$	3.734	✓			

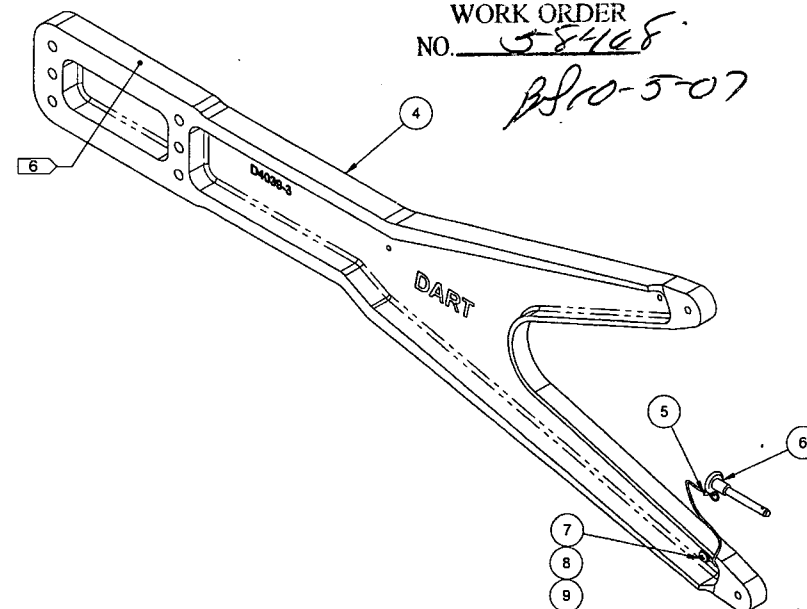
Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10/05/19	Date: 10/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58468
PS10-507

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A

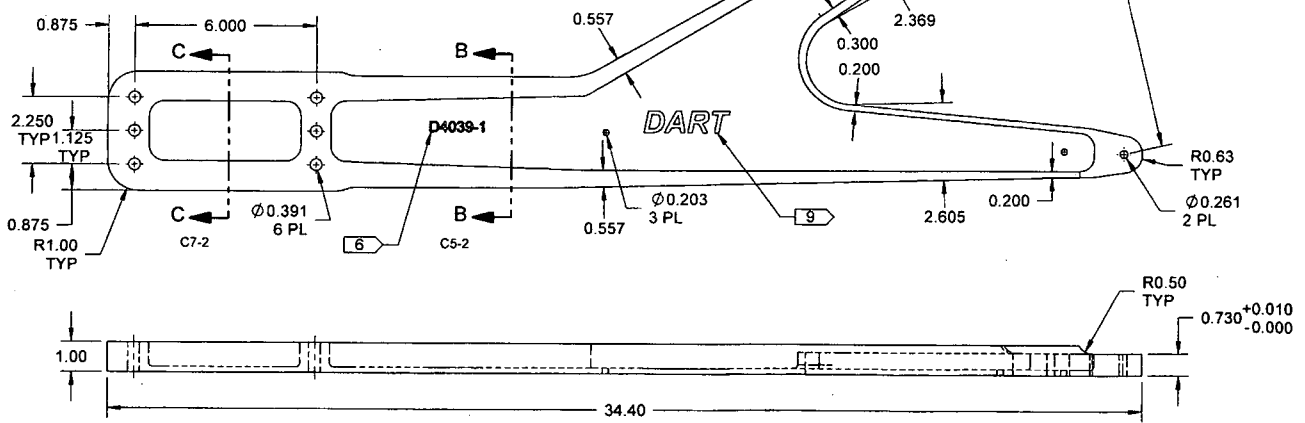
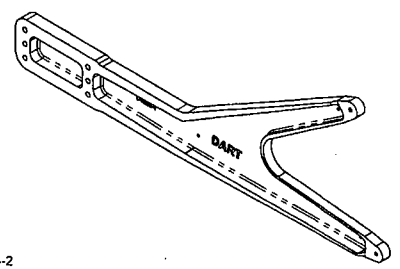
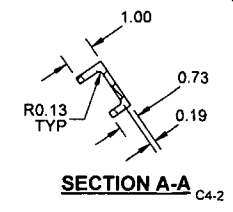
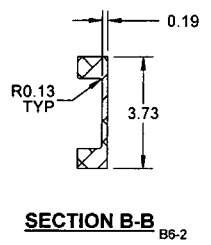
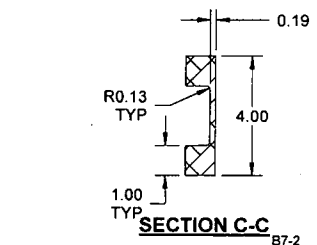
A	NEW ISSUE		09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. A
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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RELEASED
2010-04-14



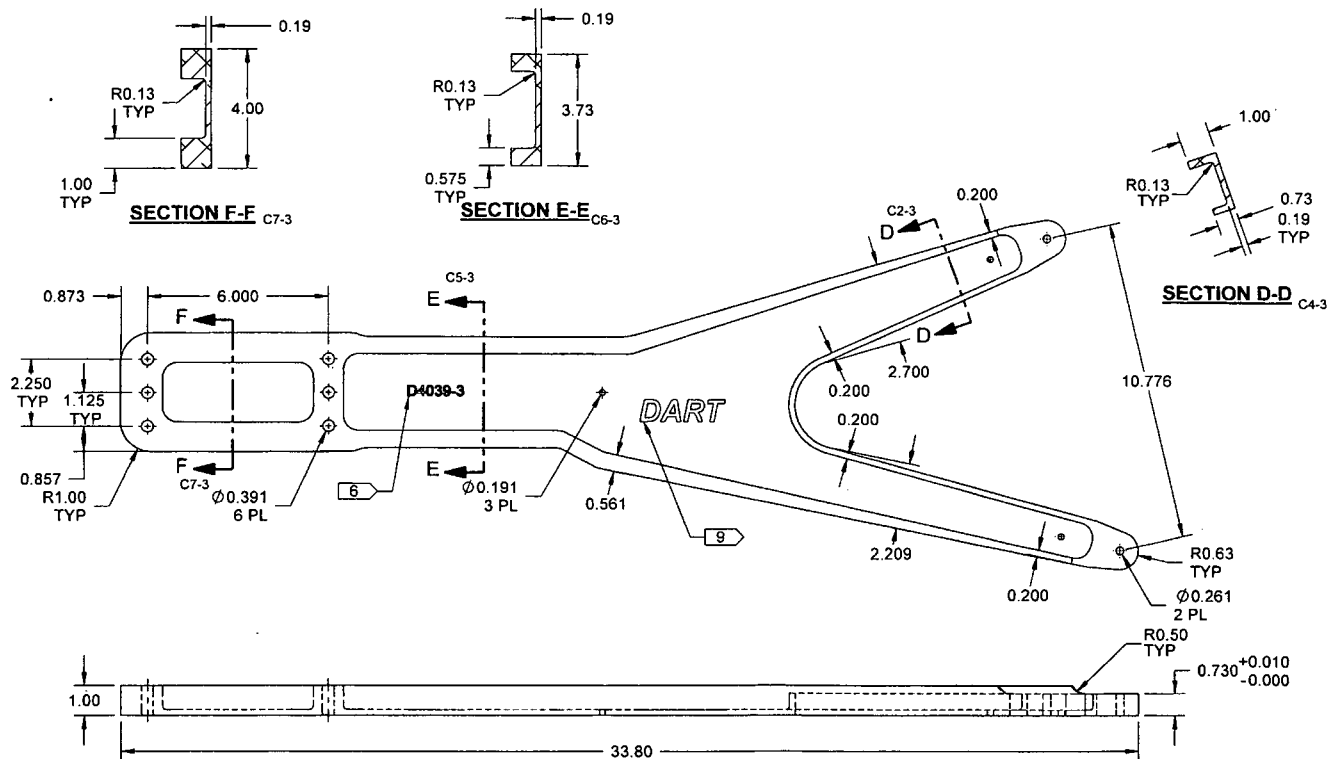
w/o 58468

D4039-1 FWD BRACKET

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
 - 7) WEIGHT: 6.64 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4039-1 REVA.SLDPRT"
 - 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-04-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4039	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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D4039-3 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REVA.SLDPR" T
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-04-14
MP

DESIGN	45	DART AEROSPACE LTD	
DRAWN	45	HAWKESBURY, ONTARIO, CANADA	
CHECKED	45	DRAWING NO.	REV. A
MFG. APPR.	45	D4039	SHEET 3 OF 3
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